

Work Order ID 66812

Monday, February 28, 2011 10:43:05 AM



Page 1

Item ID: D3255-3	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Cap					
Start Date: 2/28/2011	Start Qty: 10.00		Cust Item ID:		
Required Date: 3/11/2011	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: <u>PL</u>	Date: <u>11-02-28</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								
100	FLOW WATER JET	0.00							
	Waterjet								
	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3255		<input type="checkbox"/> Dwg Rev: <u>B</u>	<input type="checkbox"/> Prog Rev: <u>B</u>	<input type="checkbox"/> 2-				
304 .037	Deburr if necessary								(51)
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
	QC								
	Memo	0.00							
Quality Control									

B11-3-3

B11-3-3

11 03 03 (21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66812

Monday, February 28, 2011 10:43:05 AM



Page 2

Item ID: D3255-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Cap

Start Date: 2/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/11/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: *WA*

0.00



Packaging

Memo

0.00

SAP 11-03-03

21

Packaging

*****STOCK IN LARGE FAB*****

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/04

mf

11-03-03

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NOTE: Date & initial all entries

Picklist Print

Monday, February 28, 2011 10:43:11 AM

Page 1

Work Order ID: 66812

Parent Item: D3255-3

Parent Item Name: Cap



Start Date: 2/28/2011

Required Date: 3/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 06-08-01 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S22GA

Purchased

No

100

sf

47.2896

0.045

0.473684

1.



B11-3-3

304/316 .032 Sheet

Location

Loc Qty

Loc Code

MAT20

47.2896

109023

16.2896

109057

31

109057

(21)

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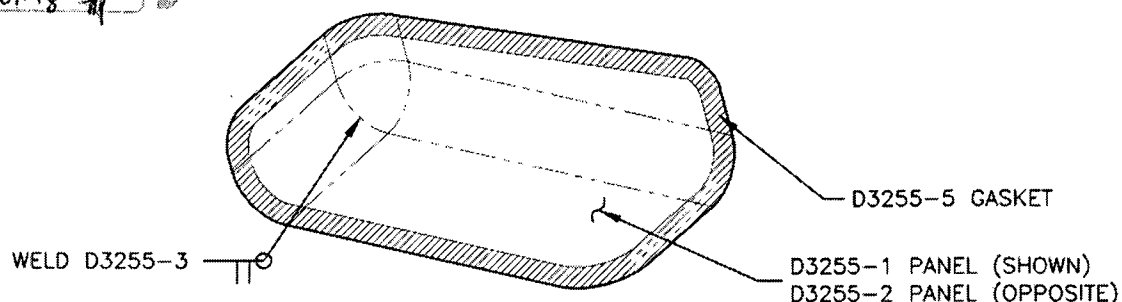
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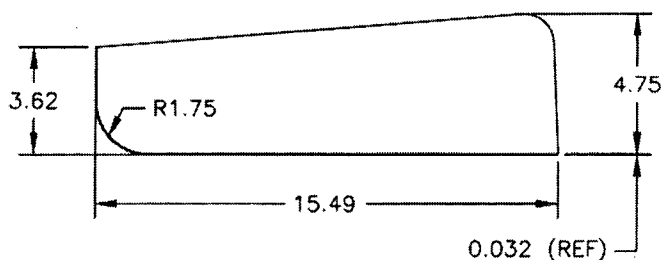
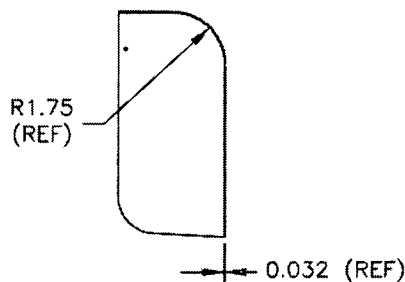
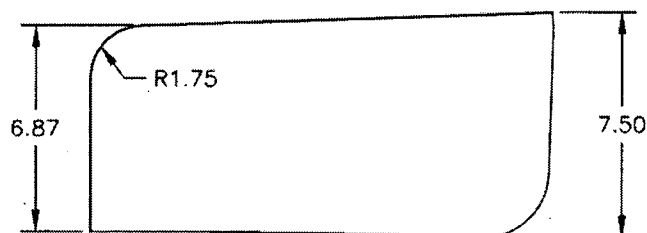


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED Ø0.098	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 46812

plu-02-25

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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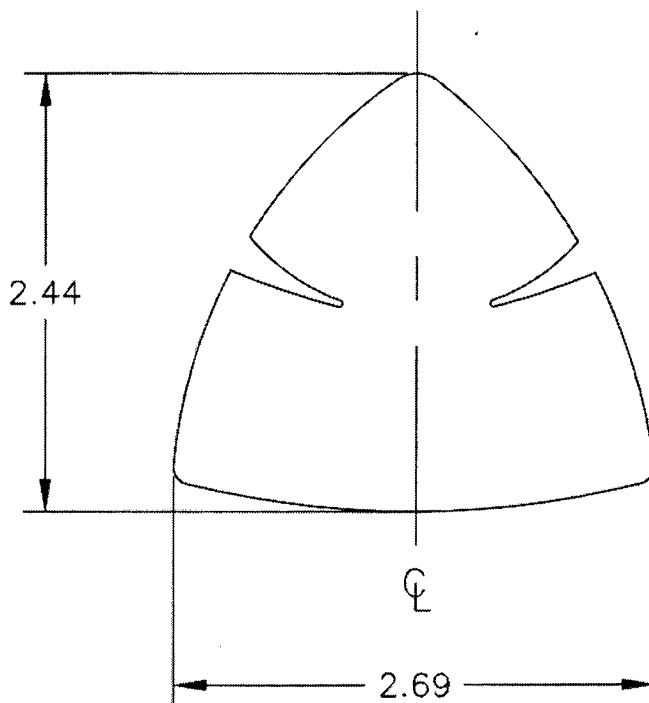
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DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.08 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

u/b 66812

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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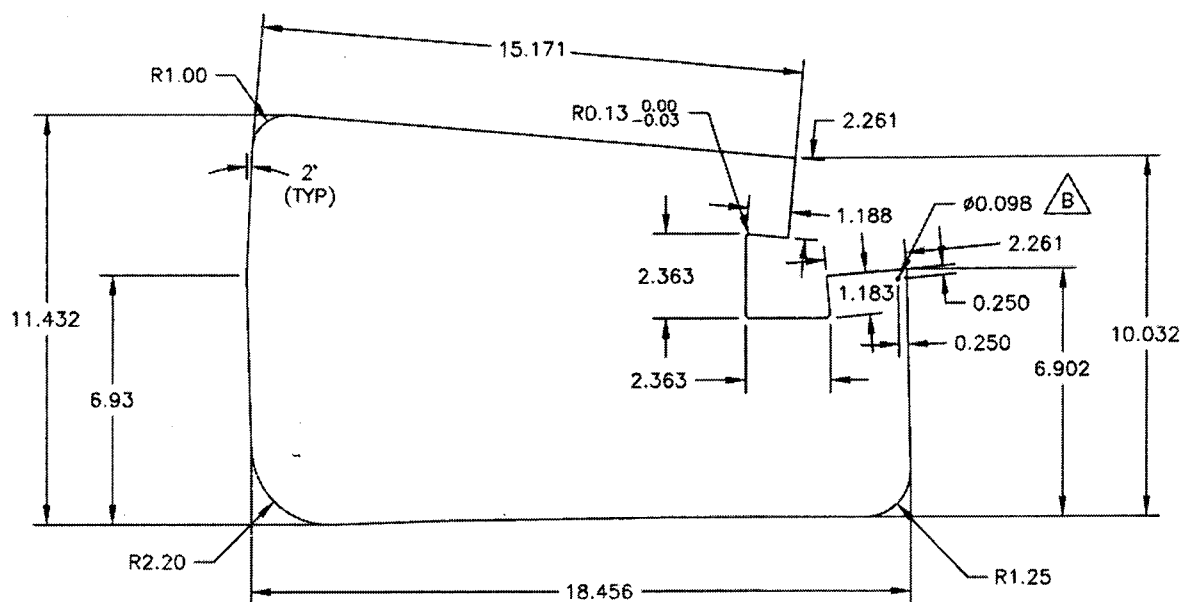
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NOTE: Date & initial all entries



DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



u/o 44812

D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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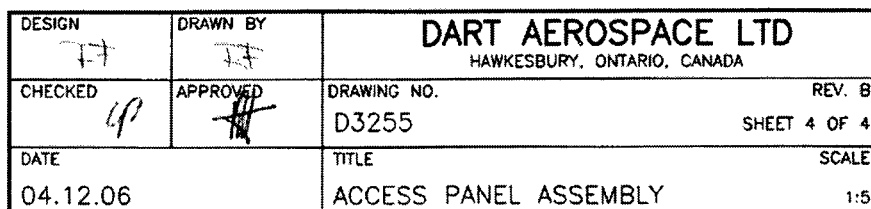
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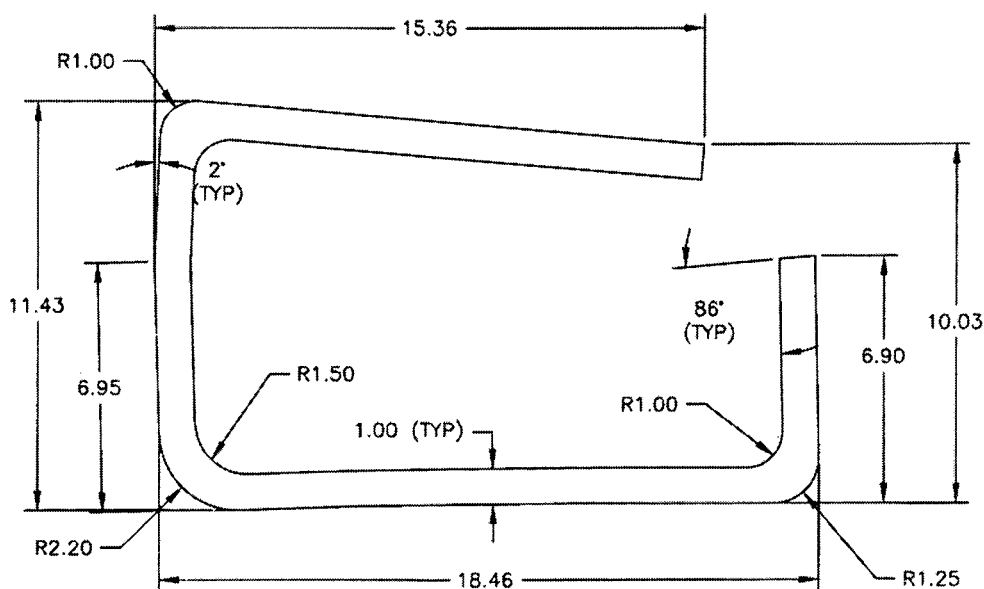
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NOTE: Date & initial all entries



RELEASED
05 01 18 ~~11~~



D3255-5 GASKET

2026812

1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES

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